



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5149-043W
Job Sheet 187580



Part No: D5149-043W

Job Qty: 6 pcs

Part Name: Aft Step Base Assembly Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/11/19 *Feb 14*

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV D SHEET 4 IPP REV:A 14.12.15 NEW ISSUE DD VERF;JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	6 pcs	1/11/19		0.00	5.17	Large Fab - 1		<i>JRL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
120	QC 9	6 pcs	1/11/19		0.00	0.00	QC 9 - 10		<i>JJ</i>
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	6 pcs	1/11/19		0.00	0.00	QC 5 - 10		<i>JJ</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

140	Handfinish - 1-1 Chemical-B4B	6 pcs	1/11/19	0.00 0.79	QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/2/19
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	6 pcs	1/11/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	

					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
160 Powdercoat - 1 White Gloss	6	1/11/19	0.00 0.14	Powdercoat - 1 - B4B		
(A) M138997	pcs			Powdercoat - 2 - B4B		
START: 3:20 O.I.T. 3:30 Finish: 3:50				Powdercoat - 3 - B4B		B219-02-20
170 QC 3	6	1/11/19	0.00 0.00	Powdercoat - 4 - B4B		
	pcs			QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		M1 19-2-22
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 38		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
180 Handfinish - 3-1 - WingWalk- B4B	6	1/11/19	0.00 0.79	Handfinish - 3 - 1 - B4B		M1 19-2-22
	pcs			Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
190 QC 3	6	1/11/19	0.00 0.00	QC 3 - 10		
	pcs			QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 38		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
200 Packaging 3-1 - Stock - B4B	6	1/11/19	0.00 0.00	Packaging 3 - 1 - B4B		
	pcs			Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		

DAS
15
9-89

DAS
FEB 25 2019 68
9-89

				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	58 FEB 26 2019
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	6 pcs	1/11/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 FEB 20 2019
Part Op 110 - Large Fab 2 (Weld per dwg A/R Aluminum rod Batch: _____) Descriptions: 120 - QC9 (QC9- Inspect visual per QSI004- Fusion Welds) 130 - QC5 (QC5- Inspect part completeness to step on W/O) 140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 150 - QC7-4 (QC7-Inspect Chemical Conversion Coat) 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 170 - QC3 (QC3- Inspect Part Finish) 180 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch _____) 190 - QC3 (QC3- Inspect Part Finish) 200 - Packaging3-2 (Identify as per dwg & Stock Location: _____) 210 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D5149-5	Step Cap	6 pcs (1 ea)	110-Large Fab - Welded Assy-1		
D5149-7	Aft Step Base	6 Ea (1 ea)	110-Large Fab - Welded Assy-1		
D5149-9	Aft Step	6 Ea (1 ea)	110-Large Fab - Welded Assy-1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Large Fab - Welded Assy-1	D5149-5	6	10	0	
	D5149-7	6	15	0	
	D5149-9	6	14	0	
Part Specifications					
Specifications could not be found.					



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5149-043W
Job Sheet 187580



Part No: D5149-043W

Job Qty: 6 ea

Part Name: Aft Step Base Assembly Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/7/18

Job Tracking No:

Due Date: 1/11/19

Created By: Jesse White

Type: SOLD

Description:

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Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Large Fab-3		
110	Large Fab	6 pcs	1/11/19	1/11/19	0.00	5.17	Large Fab 2		
120	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC9		
130	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
140	HandFinish	6 pcs	1/11/19	1/11/19	0.00	0.79	HandFinish1		
150	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC7-4		
160	Powdercoat	6 pcs	1/11/19	1/11/19	0.00	0.14	Powdercoat1		
170	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC3		
180	HandFinish	6 pcs	1/11/19	1/11/19	0.00	0.79	HandFinish3		
190	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC3		
200	Packaging	6 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		
210	QC21-SA	6 Ea	1/11/19	1/11/19	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5149-5	Step Cap	6 Ea (1 ea)	90-Start up Operation	2-5109878-4-5120 283
D5149-7	Aft Step Base	6 Ea (1 ea)	90-Start up Operation	5-107511 1-5146807
D5149-9	Aft Step	6 Ea (1 ea)	90-Start up Operation	4-5089806 2-5146943

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5149-5	6	10	0
	D5149-7	6	5	0
	D5149-9	6	4	0

Part Specifications

Specifications could not be found.

Plex 12/7/18 3:38 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 02/12/19 JARI AEROSPACE Container No: S153190 Part: D5149 - 043W Job No: 187580 Serial No/Batch: S153190 Revision: Inspector: Exp Date: Instructions: Various STC's					Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			Other/Details: _____ _____ _____		